

Date: Monday, 7/9/2007 3:44:03 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT
Job Number : 33430A	
Estimate Number : 10452	
P.O. Number : <i>NA</i>	Part Number : D32781
This Issue : 7/9/2007	Drawing Number : D3278 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NA</i>	Drawing Revision : B
Previous Run : 32657A	Material : <i>NA</i>
Written By : <i>[Signature]</i>	Due Date : 7/27/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>40</i> Um: Each
Comment : Est:A 04.04.19 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
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M105411 X 18 PCS



Comment: Qty.: 0.2454 f(s)/Unit Total: 9.8154 f(s)
Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick
(M6061T6B1.000x02.000)

Batch: *M104187* ~~*105411*~~ x 17 PCS

M105817 X 5

~~*2.001T6B1000X02.000 M105411 X 17 PCS*~~

J.L 07/09/26

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
Cut blank: 2.00" x 1.00" x 2.550" long

J.L 07/09/26

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
1- Machine as per Folio FA405 and Dwg D3278
2- Deburr and Tumble
Identify as D3278-1

8F 07/12/01

J.L 07/11/01

(42)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 07/11/01

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 07/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 8/10/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 3:44:03 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 33430A

Part Number: D32781

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(42)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HP

07-12-03

7.0

POWDER COATING

POWDER COATING



M105914

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

HP

07-12-03

(42)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

mf

07-12-04

(42)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf

07-12-04

(42)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Dart/12/05

(42)

Job Completion



HP 07-12-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 33430 A
Description: Support		Part Number: D3278-1
Inspection Dwg: D3278	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø0.099	—			
0.359	+/-0.005	0.358	—			
0.609	+/-0.010	0.614	—			
0.250	+/-0.010	0.252	—			
1.480	+/-0.005	1.481	—			
R0.125	+/-0.010	R0.125	—			
0.119	+0.005/-0.004	0.120	—			
2.439	+/-0.010	2.441	—			
1.980	+/-0.010	1.981	—			
R0.13	+/-0.030	R0.130	—			
Ø0.257	+0.005/-0.000	Ø0.260	—			
R0.375	+/-0.010	R0.375	—			
0.875	+/-0.010	0.874	—			
0.500	+/-0.010	0.370	—			
R0.400	+/-0.010	R0.400	—			
R1.00	+/-0.030	R1.00	—			
1.720	+/-0.010	1.721	—			
R0.125	+/-0.010	R0.125	—			
0.125	+/-0.010	0.128	—			

Measured by: <i>AmB</i>	Audited by: <i>B</i>	Prototype Approval:	N/A
Date: 07/11/30	Date: 07.11.30	Date:	N/A

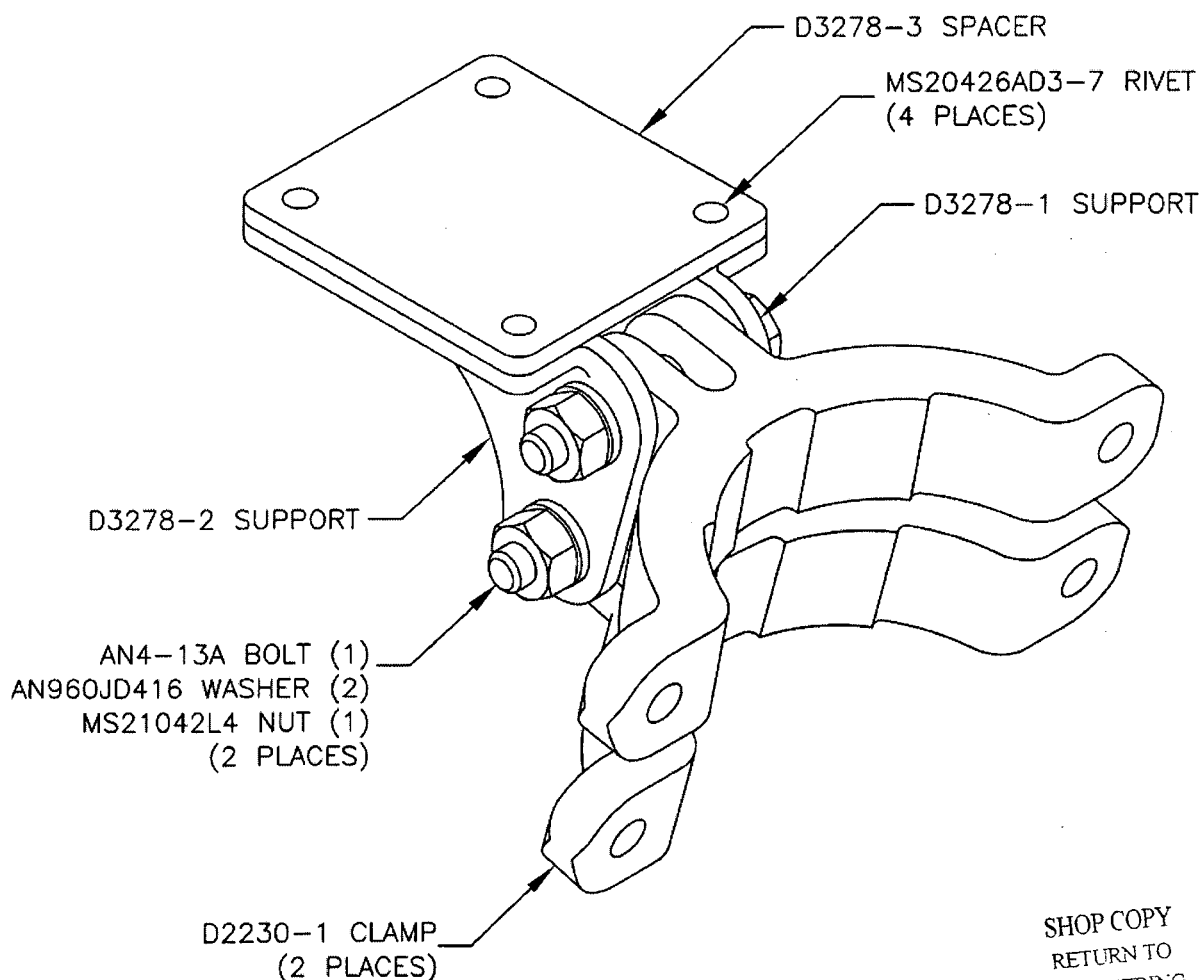
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	<i>B</i>



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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE	05.03.31			TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03			NEW ISSUE	
B	05.03.31			CHANGE DIM/TOL TO ENSURE FIT	

RELEASED
05.04.04 *[Signature]*

D3278-041 SUPPORT ASSEMBLY



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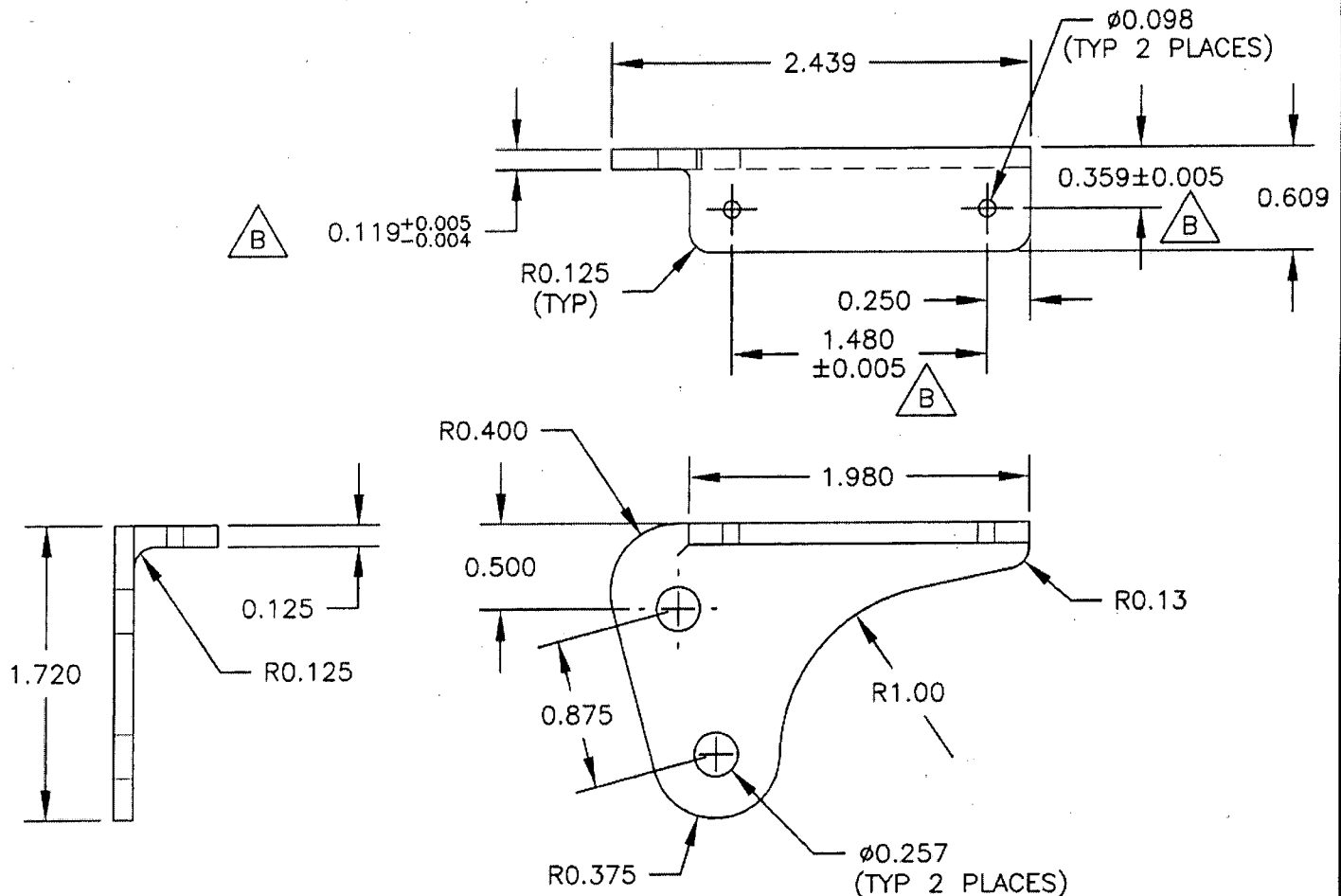
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED

05.04.04 *[Signature]*

D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/9) (REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

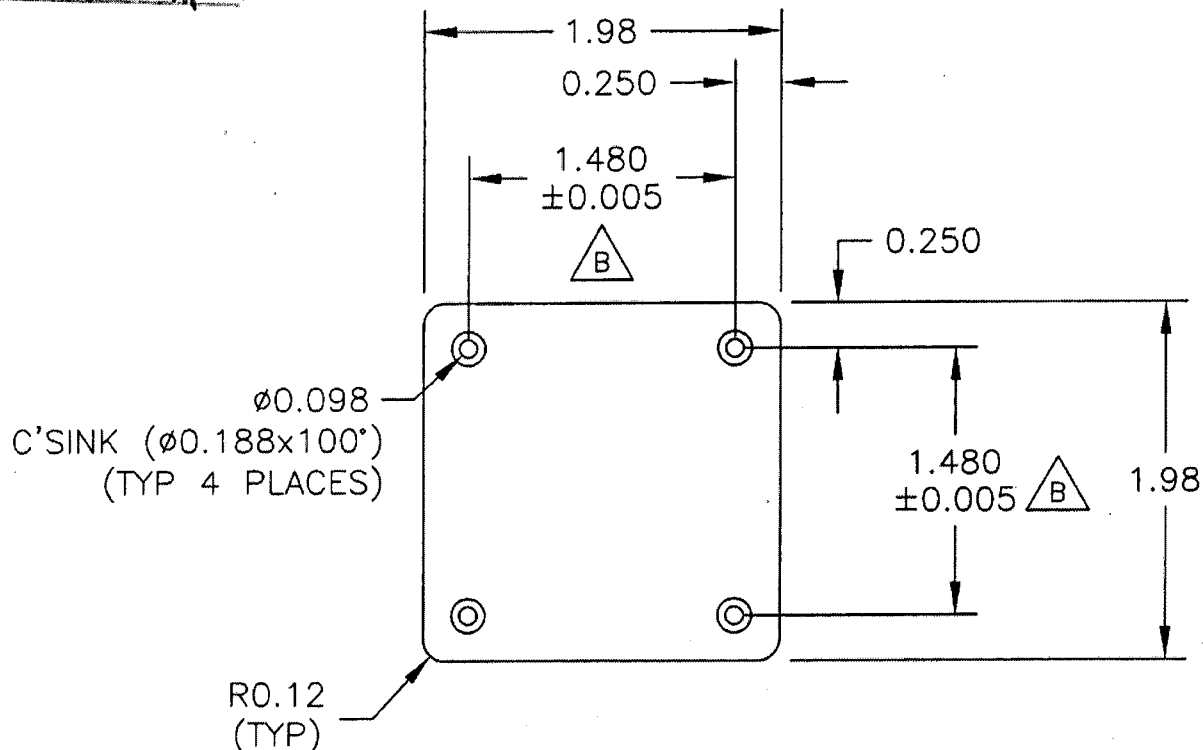
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED05.04.04 *[Signature]***D3278-3 SPACER**

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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